



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18520-1
Job Sheet 171729



Part No: RBT18520-1

Job Qty: 2 ea

Part Name: Lift Device Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520-1 REV:11 IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/15/18	0.00	0.00	Start Up Waterjet2		18/02/09
100	Waterjet	2 pcs		2/15/18	0.08	0.40	Waterjet 2 OMAX		18/02/09
110	QC	2 pcs		2/15/18	0.00	0.00	QC2 Waterjet-4		18/02/09
120	CNC Vertical Machining	2 pcs		2/16/18	1.50	1.00	HAAS 1		18/03/06
130	QC	2 pcs		2/16/18	0.00	0.00	QC2 Machining-5		18/03/06
140	QC	2 pcs		2/16/18	0.00	0.00	QC8 Machining-5		18-03-08
170	Outsource	2 pcs		2/16/18	0.00	0.00	Outsource4		18/03/23
180	Packaging	2 pcs		2/16/18	0.00	0.00	Packaging2		18/03/23
190	QC	2 pcs		2/16/18	0.00	0.00	QC6		18/03/23
200	Packaging	2 pcs		2/16/18	0.00	0.00	Packaging3-2		18/03/23
210	QC21-SA	2 Ea		2/16/18	0.00	0.00	QC21		21 MAR 27 2018

Part Op 120 - 1-Machine as per folio FB 355 FOLIO REV: 11 DWG REV: 9-85 2-Debur

Descriptions: 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to ATG: 039246 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

180 - Receive

200 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	2.1660 ft (1.083 ea)	100-Waterjet	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6B1.000X06.000	2	34	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework		Water Jet ☐	
NCR No. _____		Scrap		g. Coord. ☐	
Date: _____		Use-as-is		Packaging ☐	
Step #: _____		Suspected Unapproved		Supplier ☐	
Description Work Order Deviation		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com		Engineering ☐	
				Quality ☐	
				Other ☐	
				MRB (QSI042) Approval	
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
				Positioned Wrong ☐	
				Outside Dimensions ☐	
				Over/Under tolerance ☐	
				Part Incorrect ☐	
				Part Lost/Missing ☐	
				Part Moved ☐	
				Drawing ☐	
				Finish ☐	
				Misread ☐	
				Turning Sequence ☐	

Root Cause

Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐	Drill Holes	☐
Misidentified	☐	Past Due	☐	Misaligned/off center	☐

OTHER : _____

DART AEROSPACE

S040963

Lift Device Frame

PART NO: RBT18520 - 1

Original Serial #: S040963

Revision:

Operation: Start up Operation 02/09/18

Change No: Job No: 171729

DART AEROSPACE LTD		Work Order:	171729
Description: <i>Lifting device frame</i>		Part Number:	BBT18520-1
Inspection Dwg: BBT18520-1		Rev: 11	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.875	± 0.010	4.880	1			
1.50	± 0.030	1.555	1			
5.50	± 0.030	5.554	1			
12.75	± 0.030	12.75	1			
.50	± 0.030	.495	✓		Visual	
3.50	± 0.030	3.500	✓		"	
6.375	± 0.030	6.374	✓		"	
4.375	± 0.030	4.375	✓		"	
1.50	± 0.030	1.500	✓		"	
.365	± 0.010	.375	✓		"	
2.750	± 0.010	2.750	✓		"	
2.500	± 0.010	2.500	✓		"	
11.490	± 0.010	11.493	✓		"	
0.3152	± 0.0008	0.3153	✓		"	
1.00	± 0.030	.988	✓		"	
.320	± 0.010	.319	✓		"	
.34	± 0.030	.330	✓		"	
.13	± 0.030	.120	✓		"	
.75	± 0.030	.752	✓		"	
1.00	± 0.010	1.002	✓		"	

Measured by: <i>a gml</i>	Checked by: <i>B.A</i>	QC Inspector:
Date: <i>18/02/09</i>	Date: <i>18-03-08</i>	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

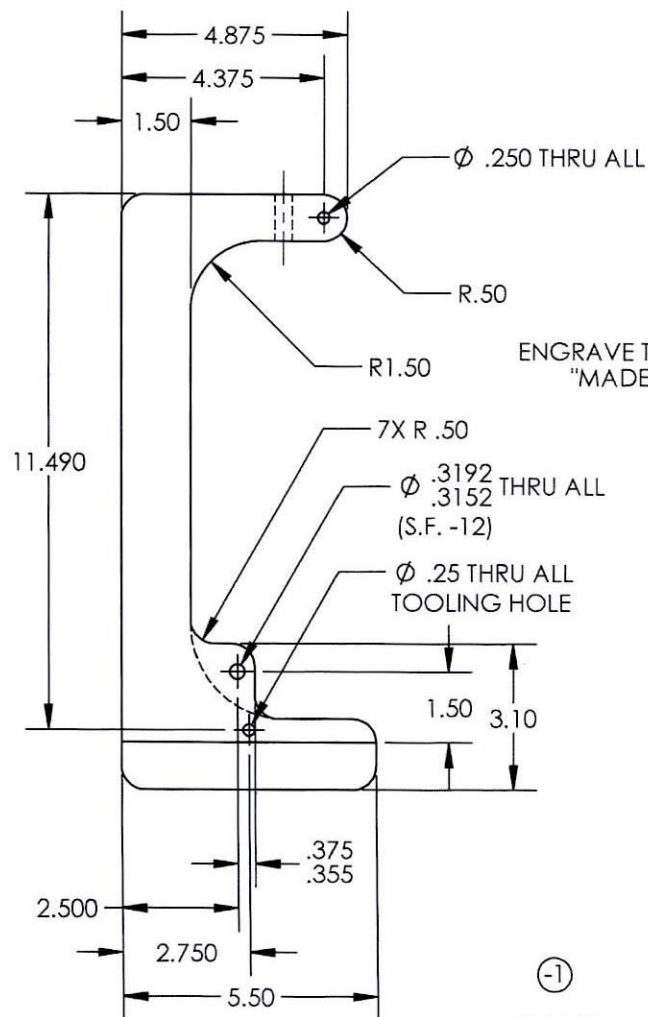
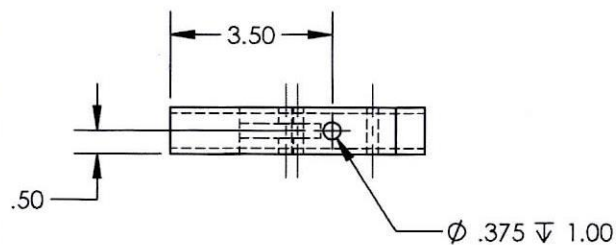
QA Closed: _____ Date: _____

Work Order update only ☐

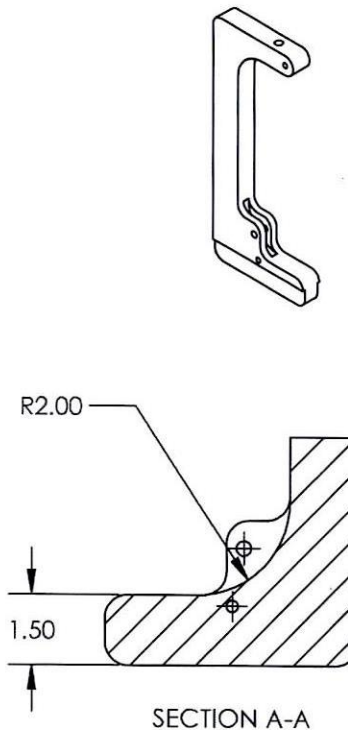
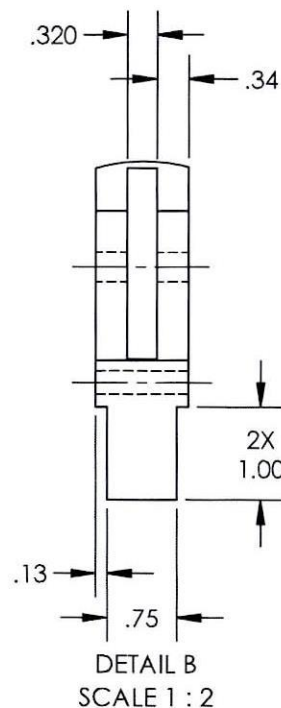
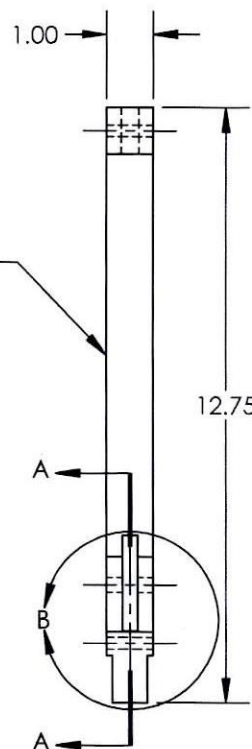
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		CHANGED -1 PIVOT HOLE FROM Ø.257 TO Ø5/16 REAMED	6/17/2009	WP	G.E.
8A		CH'D Ø.375 REAMED TO THRU PER G.E.	8/24/2010	WP	G.E.
9		-1 ADDED Ø.25 TOOLING HOLE.	8/7/2013	RJC	DW
10	16-0096	-1 CH'D DIMS WAS Ø.375 THRU IS Ø.375 ∇ 1.00, WAS REAM Ø.3125 IS Ø.3152-.3192 THRU ALL (S.F. -12), WAS 1.00 IS 2X 1.00, WAS (.125) IS .13.	8/4/2016	DPD	JAG



(-1)
FRAME



DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-1	REV 11
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
FINISH BLACK ANODIZE	.XX $\pm$.03 ANGLES $\pm$ 1°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X $\pm$.1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:4	DATE 8/17/2000
SHEET 2 OF 17	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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